

Work Order ID 63390

Thursday, October 28, 2010 10:51:47 AM



Page 1

Item ID: D3282-041 Accept
 Revision ID:
 Item Name: Float Web (206L/407)
 Start Date: 10/28/2010 Start Qty: 4.00
 Required Date: 11/12/2010 Req'd Qty: 4.00
 Reference:



Setup Start



Stop



Cust Item ID:
 Customer:

Approvals: Process Plan: *[Signature]* Date: 10-10-28 Tooling:
 QC: Date: SPC (Y/N):

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3282	Rev C

100	Skidtubes	0.00
Skidtubes	Memo	0.00
Skidtubes	1-Cut to length as per Dwg D3282. 2- inspect for surface damage as per QSI0018. 3- Deburr	

DP 10-10-28

110	HAAS CNC VERTICAL MACHINING #1	0.00
HAAS 1	Memo	0.00
HAAS CNC vertical machine #1	1-Machine as per Folio FA579 & Dwg D3282 2-Deburr	

10/11/11

120	QC2- Inspect parts off machine FAI/FAIB	0.00
QC	Memo	0.00
Quality Control		

10/11/11

4

4

4

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

G.A 10/11/12

4

0

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

4

0

BB 10/11/15

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

H 0 BE 10/11/15

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Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Skidtubes

Skidtubes

Skidtubes

Memo

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 21104929

0.00

0.00

SAD

10-11-15

(4)

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

4

10-11-15

180



Packaging

Packaging

Identify as per dwg & Stock Location: 416

Memo

0.00

0.00

DP

10-11-15

(4)

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Revision ID:

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/15
MF
10-11-15

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Picklist Print

Thursday, October 28, 2010 10:51:53 AM

Page 1

Work Order ID: 63390

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B 05.09.23 Procedure change KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS20470AD4-7

Purchased

No

100

Each

2,309.000

57

228



Rivet, Universal Head



SAD 10-11-15

Location

Loc Qty

Loc Code

ST320

2309

112492

1009

115996

1300

228

D2792-130

Manufactured

No

160

Each

56.0000

1

4



EXTRUSION



Location

Loc Qty

Loc Code

MAT06

56

61630

56

160

Each

57.0000

2

8

D3283-1

Manufactured

No



Doubler



④ 10-10-28
SAD 10-11-15

Location

Loc Qty

Loc Code

ST046

53

60203

25

62966

28

ST048

4

57725

4

3
485

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DART AEROSPACE LTD		Work Order:	13390
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.62	/		Tape	SA-1
1.500	+/-0.010	1.501	/		Ueln	SA-5
3.000	+/-0.010	3.001	/			
6.000	+/-0.010	6.001	/			
1.250	+/-0.010	1.250	/			
30.000	+/-0.010	30.000	/		Tape	
1.500	+/-0.010	1.500	/		Ueln	
72.01	+/-0.030	72.01	/		Tape	
61.75	+/-0.030	61.75	/			
57.50	+/-0.030	57.50	/			
49.19	+/-0.030	49.19	/			
43.94	+/-0.030	43.94	/			
39.69	+/-0.030	39.69	/			
26.68	+/-0.030	26.68	/			
0.55	+/-0.030	0.55	/		Ueln	
1.970	+/-0.010	1.970	/		Ueln	
2.38	+/-0.030	2.38	/		Ueln	
0.05	+/-0.030	0.05	/		Ueln	

Measured by:	SA	Audited by:	A-A	Prototype Approval:	N/A
Date:	10/11/11	Date:	10/11/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	SA

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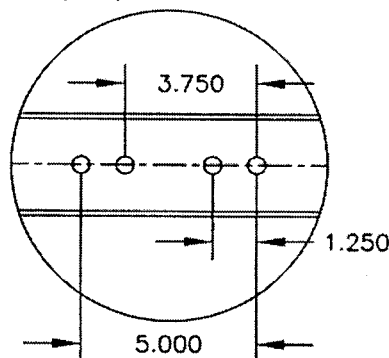
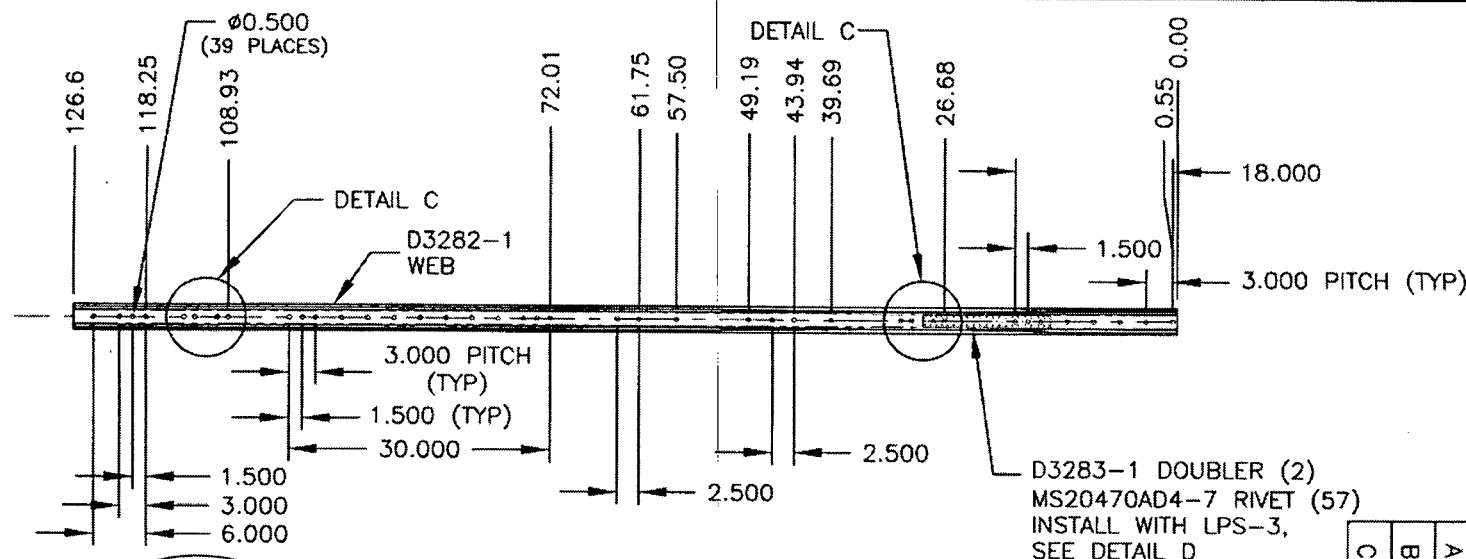
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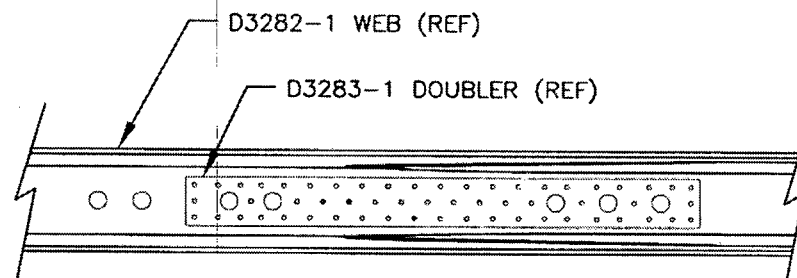
NOTE: Date & initial all entries

DART AEROSPACE USA, INC.
 UNCONTROLLED COPY
 SUBMITTAL AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 43392
 B/10-1028

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3282
DATE	TITLE	REV. C
05.08.09	FLOAT WEB, 206L/407	SHEET 1 OF 2
A	04.05.05	NEW ISSUE
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS
C	05.08.09	REMOVE D3390-1, NOW MACHINED
		SCALE 1:20



DETAIL C
 SCALE 1:5
 RIVET HOLES NOT SHOWN
 FOR CLARITY



DETAIL D
 SCALE 1:5

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

RELEASED
 05-09-12

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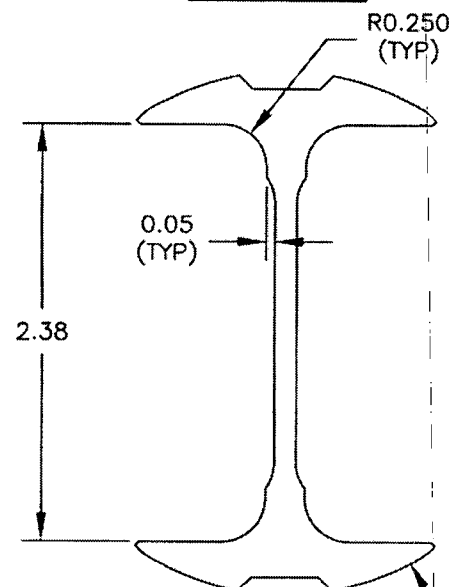
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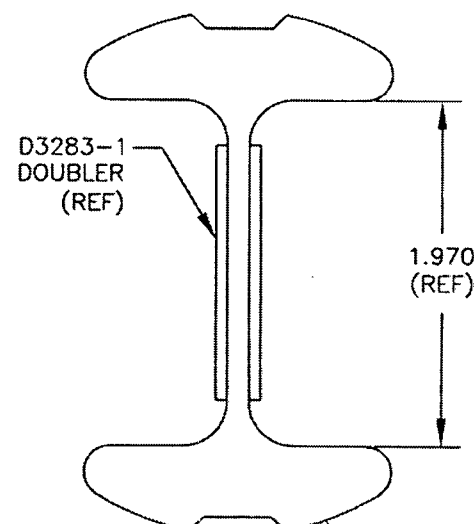
DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	TITLE	D3282	REV. C
				SHEET 2 OF 2
				SCALE 1:20
				FLOAT WEB, 206L/407

SECTION A-A



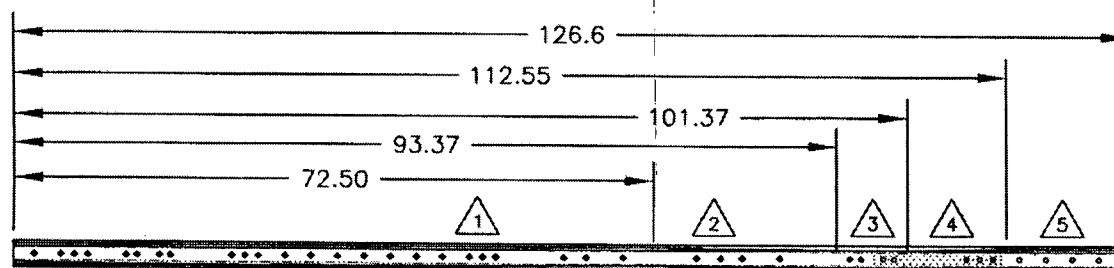
SECTION B-B



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS

w/b 4339d



RELEASED
05-04-12

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